



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship 18 July
D350-616-011
Job Sheet 179133



Part No: D350-616-011

Job Qty: 1 ea

Part Name: Full Emergency Litter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP E 03.04.04 Reformat KJ/RF IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP
REV:G 13.05.21 AS PER DWG REV.G DD VERF:JLM IPP REV:H 16.04.19 NOW @ CHG007 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Small Fab-4		<i>JUN 18 2018</i> 6
101	Small Fab	1 pcs	7/18/18	7/18/18	0.00	0.65	Small Fab-4		<i>MLC</i> 9-89
105	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC5		<i>38</i>
119	Packaging	1 pcs	7/18/18	7/18/18	0.00	0.00	Packaging1-3		<i>MLC</i>
120	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC4		<i>MLC</i>
130	Packaging	1 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1		<i>MLC</i>
135	DC	1 pcs	7/18/18	7/18/18	0.00	0.00	DC		<i>MLC</i>
140	QC21-FG	1 Ea	7/18/18	7/18/18	0.00	0.00	QC21		<i>MLC</i> 21 JUN 22 2018

Part Op 101 - 1- Assemble as per Dwg D2370 2- Transfer drill using D4812-041 as template and open to size 0.250" as per Dwg
Descriptions: D2370 AND DT9935 DRILL JIG 3- Ensure fit of D4812-041 and remove for shipping ***D4812-041 MUST STAY WITH
LITTER FRAME*** 4- Deburr

130 - Identify and pack for shipping as per PPP D350-616-011 Location: *FG034* PPP Rev: _____

135 - Photocopy bluefile and create labels per PPP D350-616-011 CHG007

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2370-1	Litter Frame Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5056667</i>
D4812-041	Patient Stop Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5064686</i>
D350-616-013	Deck Plate & Tie Down	1 Ea (1 ea)	119-Packaging	<i>5076637</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2370-1	1	1	0
	D4812-041	1	2	0
119-Packaging	D350-616-013	1	3	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Supervisor _____ Coordinator _____ Date: 06/16/18 Part: D350 - 616 - 011 Job No: 179133 Serial No/Batch: S081702 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Container No: S081702 DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartco.com www.dartaerospace.com	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power ☐	Wrong Dimensions tolerance Missing Turning Sequence ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/F ☐					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong ☐					
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-se' ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislak ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Fu ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐					
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY

D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

RELEASED
2013-05-16
MD

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 25.73 Lbs

REV.	DESCRIPTION	BY	DATE
D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>21</i>	D2370	SHEET 1 OF 2
APPROVED	<i>22</i>	TITLE	SCALE
DE APPR.	<i>23</i>	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



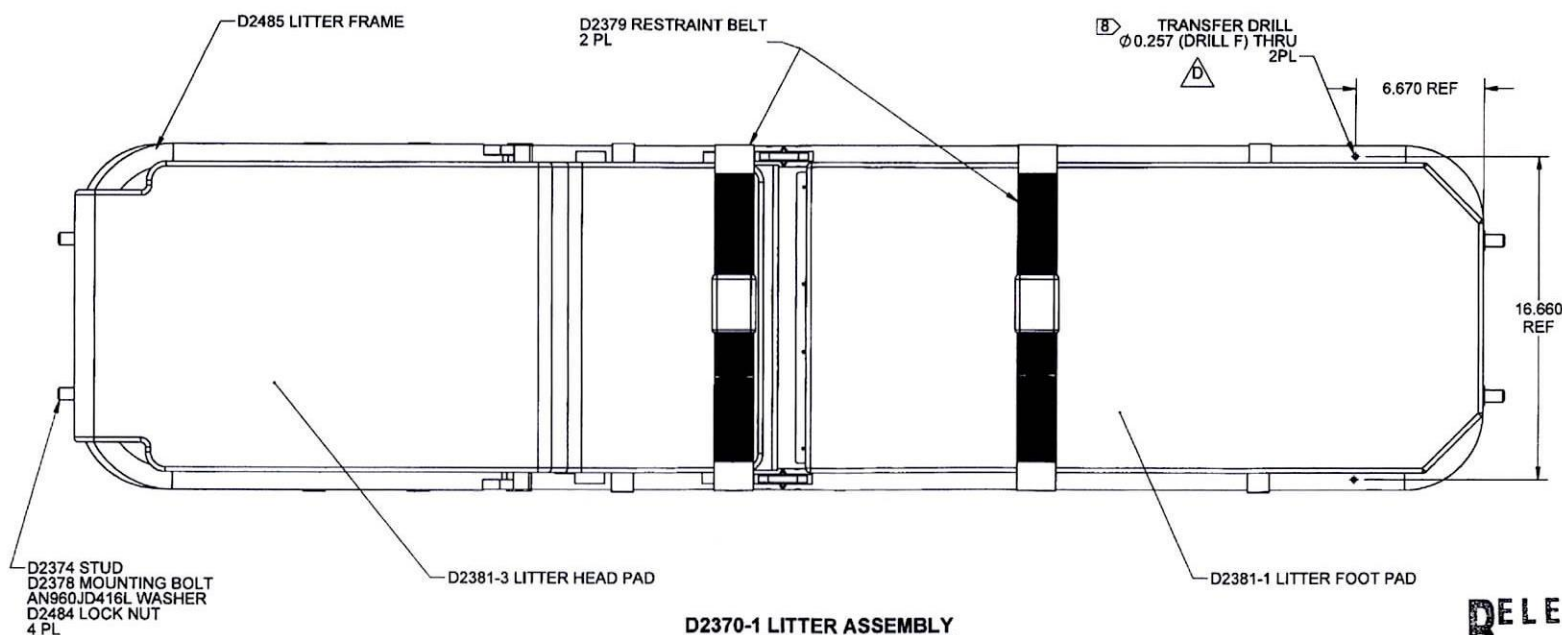
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



RELEASED
2013-05-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO. D2370	REV. D
MFG. APPR.	2/1		SHEET 2 OF 2
APPROVED	2/1	TITLE LITTER ASSEMBLY	SCALE NTS
DE APPR.	2/1		
DATE	13.03.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					